

Work Order ID 71718

Thursday, July 07, 2011 1:01:05 PM



2VSH

Page 1

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/07/07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1010 .048

1-Cut as per Dwg D3319

Dwg Rev: *B*

Prog Rev: *R*

2-Deburr if necessary,

11-8-11

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-8-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Swloslu

(78)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D339-1 PAR #: _____ Fault Category: Large PAB NCR: Yes No DQA: _____ Date: _____
 Resolution: AS IS Disposition: Good AS IS QA: N/C Closed Date: _____

NCR: <u>71718</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11.08.12</u>	<u>160</u>	<u>USED ²²⁸ ROD</u> <u>INSTEAD OF 7560.</u> <u>2059B</u>	<u>CP</u> <u>11.08.12</u> <u>PS/07L</u>	<u>Acceptable</u>			<u>CP</u> <u>11.08.12</u> <u>PS/07L</u>	
<u>11.08.12</u>	<u>160</u>	<u>USED 2059B INSTEAD</u> <u>OF 228</u> <u>R.C. LACK of Attention</u> <u>(Drawing + w/o clear)</u>	<u>CP</u> <u>11.08.12</u> <u>PS/07L</u>	<u>Acceptable</u>	<u>CP 11.08.12</u> <u>JRL 11.08.12</u>	<u>S</u> <u>11.08.12</u>	<u>CP</u> <u>11.08.12</u> <u>PS/07L</u>	<u>S</u> <u>11.08.12</u>

NOTE: Date & initial all entries

Work Order ID 71718

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Item ID: D3319-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1- Form using DT8326 & DT8261 as per Dwg D3319Rev: B
2- Form flat on press using DT8776 block

③

②

11-08-11

150

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

J 11-08-12

②

160

0.00



Weld per dwg A/R Hardcoat steel Batch: M118453

Large Fab

Memo

0.00

Large Fab

1- Layout weld location as per Dwg D3319 using jig D3319-1T3
2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: B
Qty Part Number Description Batch
A/R N/A 228/7560 Hardcoat Rod ✓

x8

11-08-12

JBL / Ppl 11-08-12

PTO
Previous Price

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71718

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Item ID: D3319-1

Accept

Revision ID:

Item Name: Wearplate

Start Date: 7/7/2011 Start Qty: 6.00

Required Date: 7/21/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Suloe12

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suloe12

(X8)

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M117338

START TIME: 10:15AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:45AM

X8

Suloe12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 71718

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Item ID: D3319-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 7/7/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8X 11/08/12

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX
For Product Eligibility see PDA05-18 and Stock
Location: 497

11/08/12 8X

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/12

11-08-12 8X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

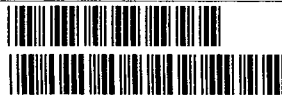
Thursday, July 07, 2011 1:01:02 PM

Page 1

Work Order ID: 71718

Parent Item: D3319-1

Parent Item Name: Wearplate




Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B05.10.14 Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA  1010/1025 SHEET .048		Purchased			No	100	sf	318.5000	0.628	3.966316		5. B11-8-11	

Location

MAT019

116268

117806

Loc Qty

318.5

26.5

292

Loc Code

116268

116268

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

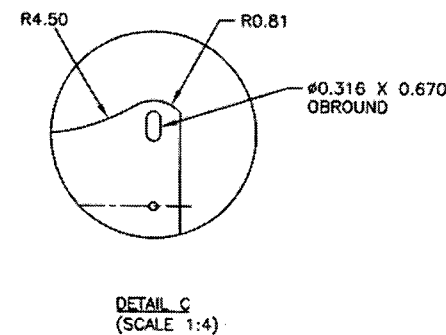
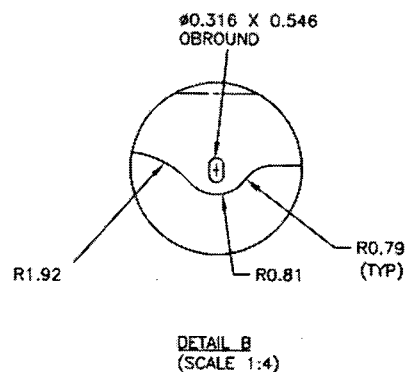
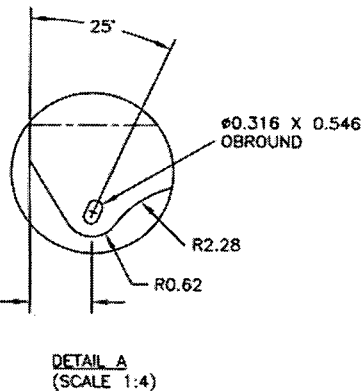
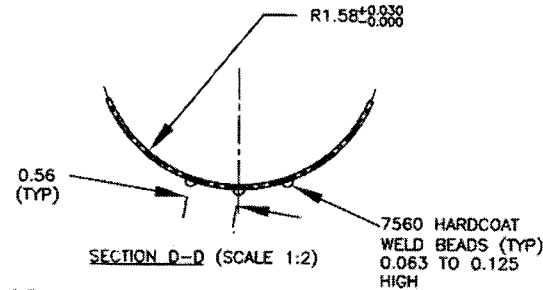
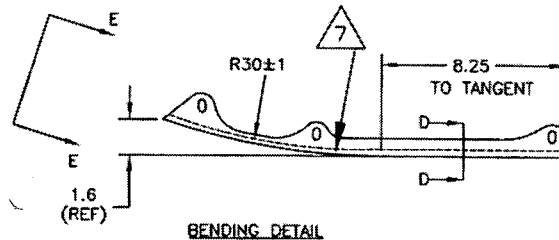
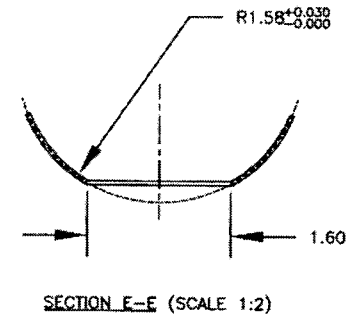
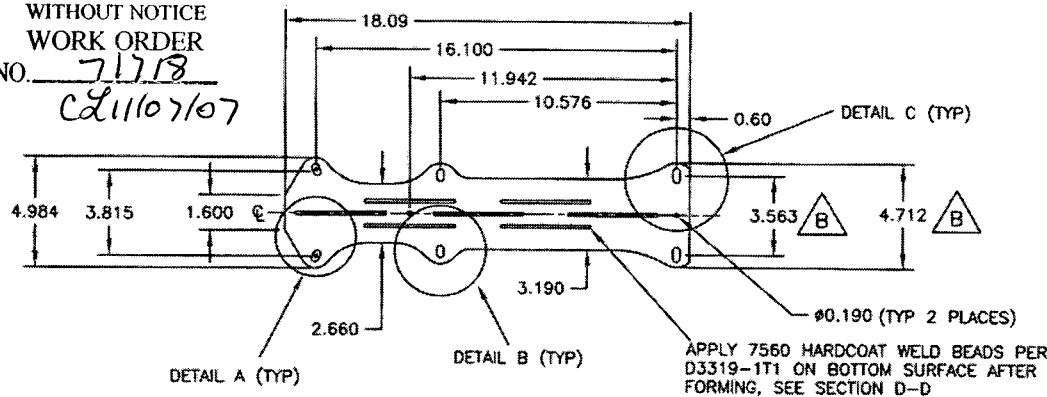
SHOP COPY

RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 71718
CA11107107

FLAT PATTERN



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:

"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DESIGN	DRAWN BY	DART AEROSPACE LTD
PH1	PH1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH1	PH1	D3319
DATE	TITLE	SHEET 1 OF 5
05.06.06	WEARPLATE	SCALE 1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES/REDUCE WIDTH -3/-5/-7

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RELEASED
05-09-30

DART AEROSPACE LTD		Work Order:	71718
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.979	2		V B02	
1.600	+/-0.010	1.600	2		V	
2.660	+/-0.010	2.666	2		V	
3.190	+/-0.010	3.192	2		V	
3.563	+/-0.010	3.560	X		V	
4.712	+/-0.010	4.707	2		V	
0.60	+/-0.030	.601	2		V	
10.576	+/-0.010	10.576	2		T B01	
11.942	+/-0.010	11.942	2		T	
18.09	+/-0.030	18.09	>		T	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	319X551	2		V	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	319X.679	2		V	
Ø0.190	+0.005/-0.001	.194	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-8-11	Date: 11/08/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	[Signature]